

Work Order ID 76467

November-15-11 8:10:58 AM

76467

Page 1

Item ID: D3254-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Side (RH)
 Start Date: 15/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 29/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3254	Rev A					(4)			

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3254

Dwg Rev: A

Prog Rev: A 2-

Deburr if necessary

2004.062

B12-5-30

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-5-30

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

W 12:05 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 15/11/2011 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 29/11/2011 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Insp.
Stamp

130

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

Bend as per dwg D3254

140

QC5- Inspect part completeness to step on W/O

0.00

140

0.00⁴

QC

Memo

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

0.00

HandFinish

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:40	OVEN TEMPERATURE:							
	FINISH TIME: 4:10								
W121279	3200F								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: 51145	0.00							
180									
Packaging	Memo	0.00							
Packaging									

4x 0 12/06/04
 H 0 12/06/05
 4 51145 12/06/05

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Revision ID:

Stop ***NS2***

Item Name: Side (RH)

Start Date: 15/11/2011 Start Qty: 4.00

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Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/6/7 JF
ML512406105

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NOTE: Date & initial all entries

Picklist Print

November-15-11 8:11:03 AM

Page 1

Work Order ID: 76467

76467

Parent Item: D3254-2

D3254-2

Parent Item Name: Side (RH)

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B 04.10.26 D3254-2 no longer made in-house
IPP c 08.11.13 in-house EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	33.5000	3.37	14.18947	16.		
M2024T3S 063										**		B12-5-30	
2024-T3 .063 sheet													

Location

Loc Qty

Loc Code

MAT022

33.5

117392

33.5

119416

4

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76462
Description: Side (Dual Battery Rack)		Part Number: D3254-2
Inspection Dwg: D3254	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.20	+/-0.030	5.26	X		V BOL	
4.15	+/-0.030	4.144	X		V	
R0.19	+/-0.030	1.14	X		R.G.	
1.103	+/-0.010	1.104	X		V	
0.300	+/-0.010	0.294	X		V	
Ø0.098	+0.005/-0.000	0.102	X		V	
1.300 Pitch	+/-0.005	1.302	X		V	
21.056	+/-0.010	21.056	X		T BOL	
19.000	+/-0.010	19.00	X		T	
1.003	+/-0.010	1.005	X		V	
Ø1.125	+0.005/-0.000	1.125	X		V	
5.403	+/-0.010	5.400	X		V	
Ø1.500	+0.005/-0.000	1.500	X		V	
2.750 Pitch	+/-0.005	2.752	X		V	
5.500	+/-0.010	5.494	X		V	
1.653	+/-0.010	1.661	X		V	
3.75	+/-0.030	3.740	X		V	
10.810	+/-0.010	10.806	X		PROWSEN	
8.00	+/-0.030	7.946	X		V	
R0.50	+/-0.030	0.50	X		R.L.	
2.750 Pitch	+/-0.005	2.756	X		V	
4.125	+/-0.010	4.128	X		V	
22.946	+/-0.010	22.946	X		T	
R0.30	+/-0.030	0.30	X		R.L.	
9.90	+/-0.030	9.910	X		P	
11.77	+/-0.030	11.777	X		P	
1.82	+/-0.030	1.817	X		V	
2.17	+/-0.030	2.168	X		V	
20.10	+/-0.030	20.10	X		T	
0.953	+/-0.010	0.952	X		V	
R0.125	+/-0.010	0.125	X		R.L.	
Grain along 20.10	N/A				EYES	

Measured by: B	Audited by: [Signature]	Prototype Approval:	N/A
Date: 12-5-30	Date: 12 05 30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	[Signature]

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

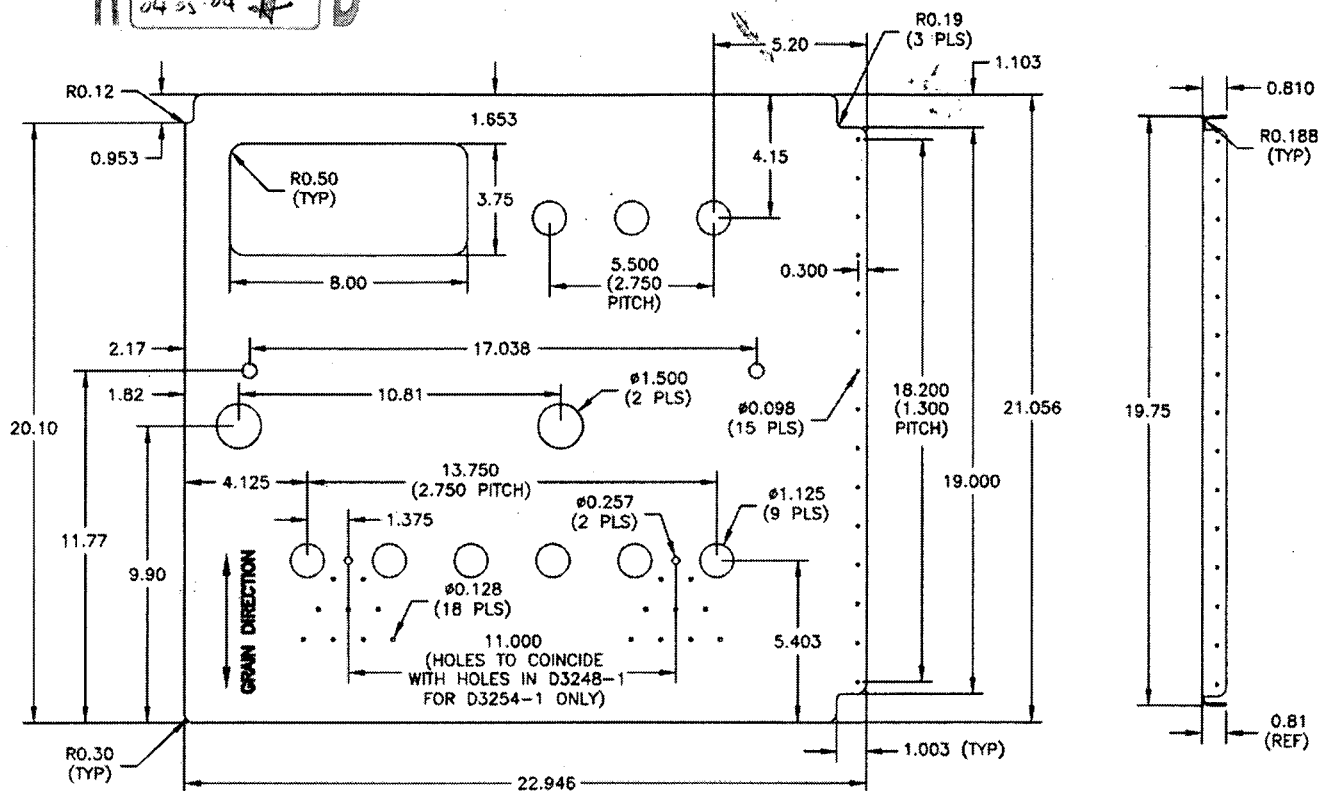
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

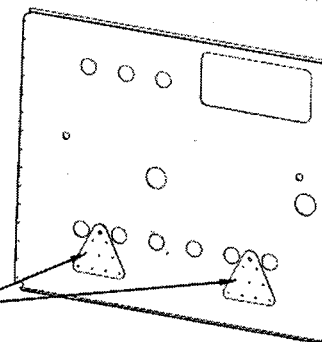
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3254	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE SIDE (DUAL BATTERY RACK)	SCALE 1:6
A	04.04.06	NEW ISSUE	

RELEASED
04-05-04**D3254-1/-2 FLAT PATTERN**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76467 M.C.S.
11/11/15

**D3254-1 BEND DETAIL (SHOWN)
D3254-2 OPPOSITE**

INSTALL D3248-1
USING MS20470A4-5
RIVETS

**D3254-041****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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